

Date: Wednesday, 5/31/2006 7:39:23 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	TUBE ASSEMBLY			
Job Number	27297	Part Number	D2003041			
Estimate Number	10921	Drawing Number	D2003 REV B			
P.O. Number	N/A	Project Number	N/A			
This Issue	5/31/2006	S.O. No.	N/A			
Prsht Rev.	NC	Type	SMALL /MED FAB			
First Issue	N/A	Material	N/A			
Previous Run	N/A	Due Date	6/30/2006	Qty:	5	
Written By	See Comment Below					Um: Each
Checked & Approved By	KJ 06-05-31					
Comment	Est: B 99.11.11 Re-format EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	DC	DOCUMENT CONTROL			Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D2003-041 Batch: KJ 06/05/31 (5)
2.0	M304TR0500W035	304 RD Tube .500 x .035W			Comment: Qty.: 0.5145 f(s)/Unit Total : 2.5725 f(s) Material: 1/2"AE x 0.035" wall AISI 304 SS tubing Batch: 1100928 FF 06.06.08 5
3.0	M26506	Firesleeve-crkl .375IDia			Comment: Qty.: 0.5250 f(s)/Unit Total : 2.6250 f(s) Material: M2650-6 Heat sleeve Batch: 1117521 FF 06.06.08 5
4.0	MS208198J	Sleeve			Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 2 MS20819-8J Sleeve M16735 FF 06-06-08 5
5.0	AN8188J	Nut			Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 2 AN818-8J Nut M16735 FF 06-06-08 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

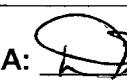
Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Wednesday, 5/31/2006 7:39:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 27297

Part Number: D2003041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2182 Heat Shrink



Comment: Qty.: 0.3750 f(s)/Unit Total : 1.8750 f(s)

Pick:

Qty Part Number Description

1 D2182-045 Heat shrink

Batch

B21864A

FF 06.06.08

5

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut: 5.88" long as per Dwg D2003

2-Cut: 6.00" long as per Dwg D2003

3-Form tube as per template D2003-041

4-Assemble as per Dwg D2003

} FF 06.06.13

5

8.0 QC5 INSPECT WORK TO CURRENT STEP



Jcc 06.13 5

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 13

Re/6/18 (5)

10.0 DC DOCUMENT CONTROL



DP 06/06/14 (5)

Comment: DOCUMENT CONTROL

Inspection Level 21

u 06.06.14

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	
DATE 99.06.08		REV. B SHEET 1 OF 2	
		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
		SCALE	
A 90.04.09		NEW ISSUE	
B 99.06.08		UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
99.06.08 LK

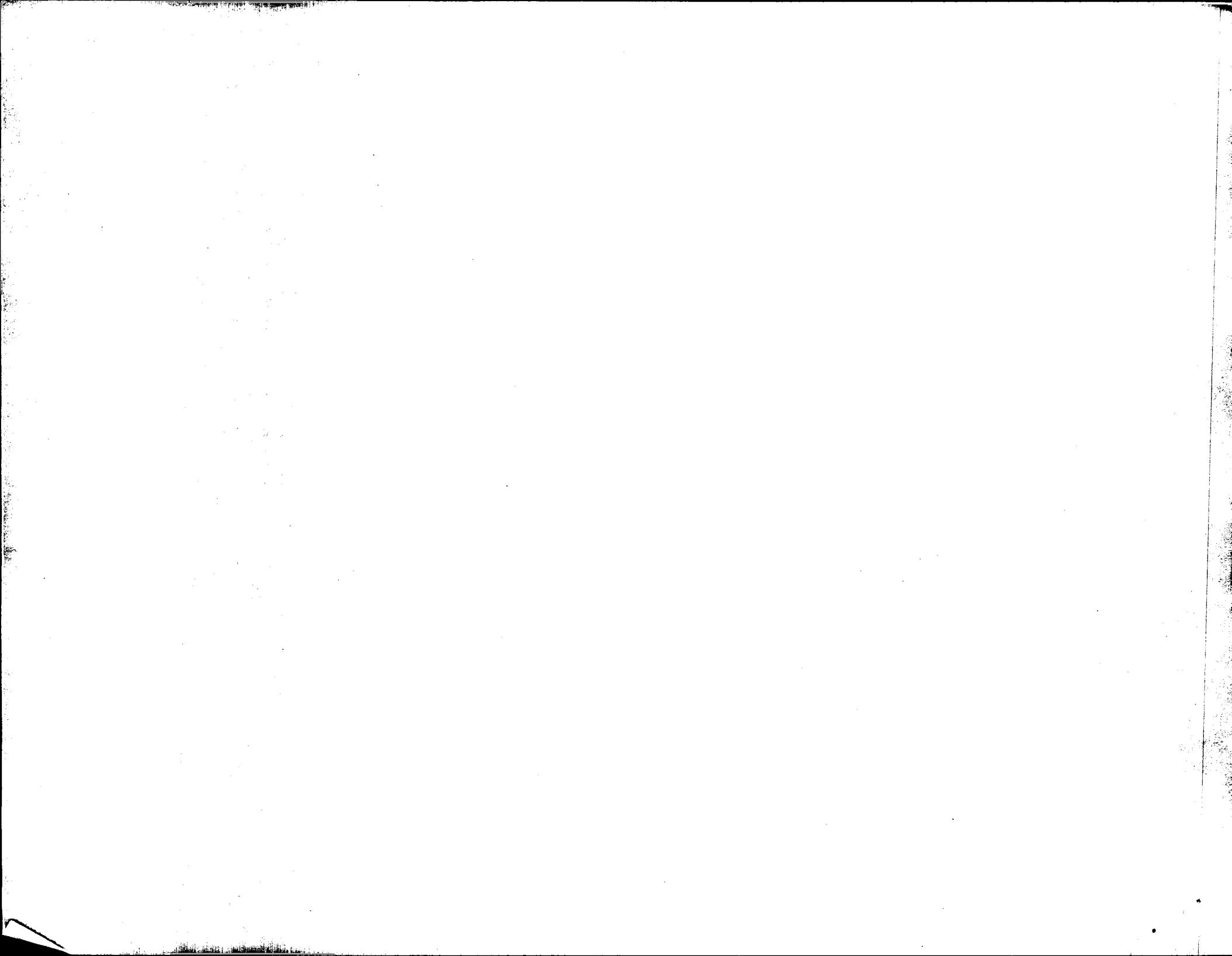
P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/87}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

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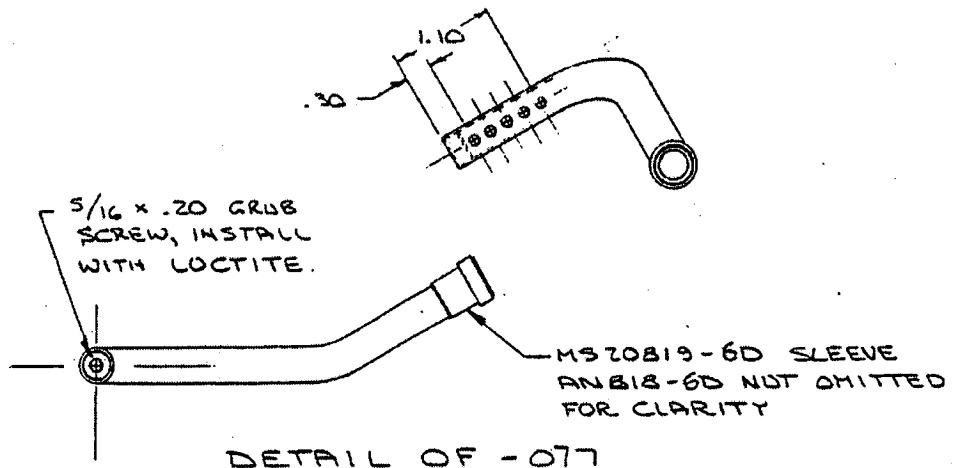
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2003
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS

REV. B
SHEET 2 OF 2**RELEASED**
99.06.09 K

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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WORK ORDER

NO. 27297